

Work Order ID 55595

January 22, 2010 11:47:40 AM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	350 Basket Base					
Start Date:	1/22/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/01/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-1-22	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100	Large Fab	0.00							
	Large Fab								
	Memo	0.00							
	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221								
	2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221								
	3- tack weld mesh on basket as per dwg D2221								
	A/R ER316 S.S. Rod Batch: 4109213								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10/01/28 (1x)

10/01/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

January 22, 2010 11:47:40 AM

[illegible]

Abstract

[illegible]**Cust Item ID:**

Customer:

Reference:

[illegible]

Stop

Abstract

**Insp.
Stamp**

$\Rightarrow \text{Solubility}$

QC

Memorandum

0.00

Quality Control

0.00

[illegible]

Powdercoat

Powder Coating

Memo

1- Plug holes prior to

0.00

\Rightarrow 10-02-02

41 0

1ST COAT: 7:30 AM
START TIME:

START TIME: 1:50 AM
OVEN TEMPERATURE: 400°C

FINISH TIME: 8:00

*****2nd coat if necessary*****

2ND COAT: 5.00

START TIME: 8:15 AM
OVEN TEMPERATURE: 400° F

FINISH TIME: 8:45 AM

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Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 1/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 10/02/03

150

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

0.00

Packaging

ES 10/02/03

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03
ME
10-2-3

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Picklist Print

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Work Order ID: 55595



Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 1/22/10

Required Date: 2/01/10

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 13.0000 1.0000



Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

12

53662

12

D2221-5 Manufactured No 100 Each 10.0000 2.0000



Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

10

53656

2

54204

8

D2221-7 Manufactured No 100 Each 5.0000 1.0000



Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

5

53659

1

54205

4

2x SY 10/01/26

2x SY 10/01/26

1x SY 10/01/26

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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No 100 Each 33.0000 2.0000



Basket Hinge

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 30

50024 2

54863 28

Main Warehouse

WA 3

53831 3

1x

10/01/26

1x

D2235-1 Manufactured No 100 Each 12.0000 2.0000



Basket Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 12

50565 3

54206 9

2x

10/01/26

January 22, 2010 11:47:39 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 49.0000 2.0000



Mounting Bracket



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 46

46086 2

48428 1

51120 2

54862 41

Main Warehouse

WA 3

50872 1

51745 2

2x *SY 10/01/26*

D3442-1 Manufactured No 100 Each 24.0000 2.0000



Shim



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1

46767 1

Main Warehouse

WA 23

53386 5

54071 18

2x *SY 10/01/26*

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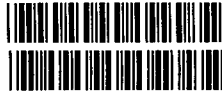
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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3825-041 Manufactured No 100 Each 4.0000 2.0000



Rib Assembly (Basket End)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

4

53902

4

2x *SY* 10/01/26

D3826-041 Manufactured No 100 Each 6.0000 2.0000



Rib / Gusset Assembly

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

6

53721

2

54657

4

2x *SY* 10/01/26

D3827-041 Manufactured No 100 Each 7.0000 1.0000



Rib Assembly (Inboard)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

7

53661

1

53901

6

1x *SY* 10/01/26

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3832-1 Manufactured No 100 Each 1.0000 1.0000



Mesh (Base)



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1

53874

1

1x *SH* 10/01/26

D3833-1 Manufactured No 100 Each 14.0000 2.0000



Mesh (Base End Face)



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

14

50025

2

53214

2

54074

2

54278

8

2x *SH* 10/01/26

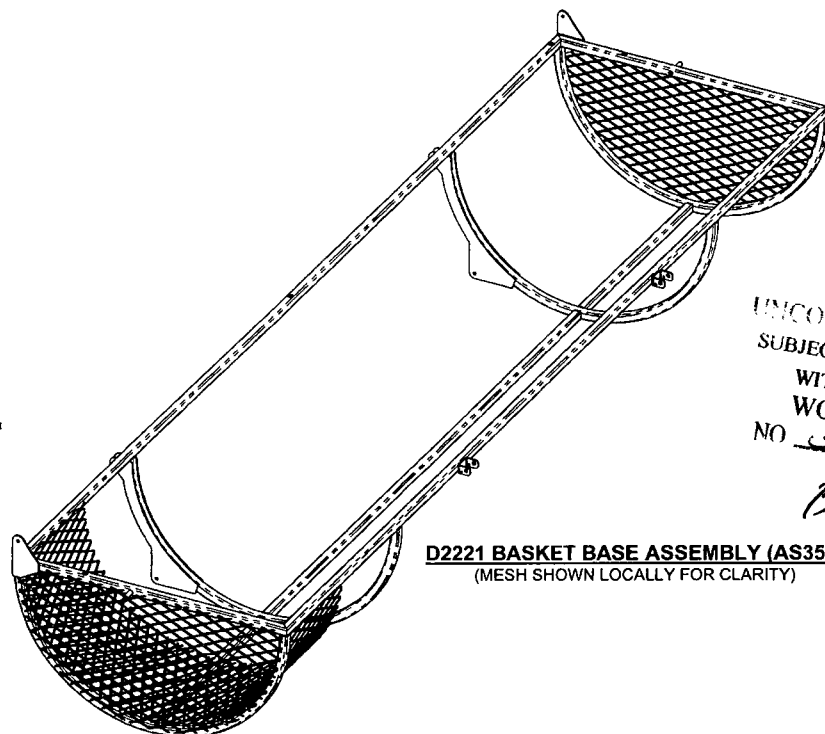
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 35595
BS-0-1-22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

H

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3625-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BS		
CHECKED	BS	DRAWING NO.	REV. H
MFG. APPR.	BS	D2221	SHEET 1 OF 5
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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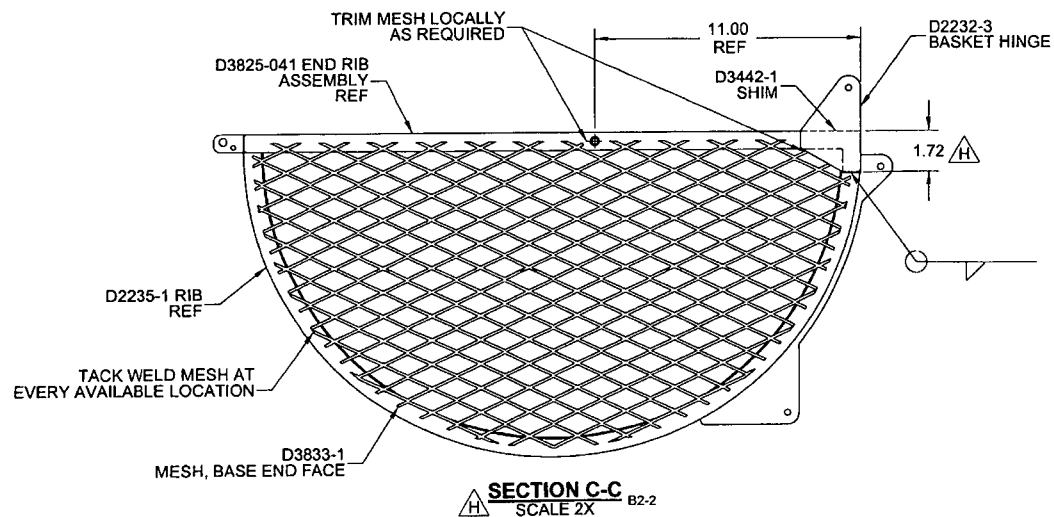
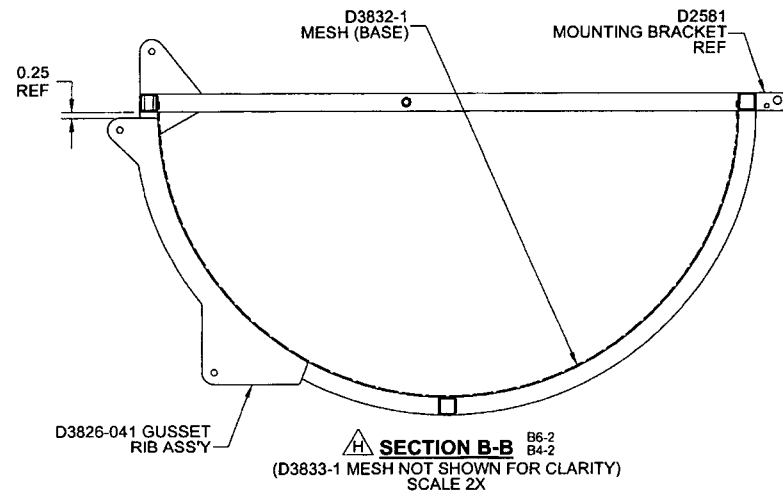
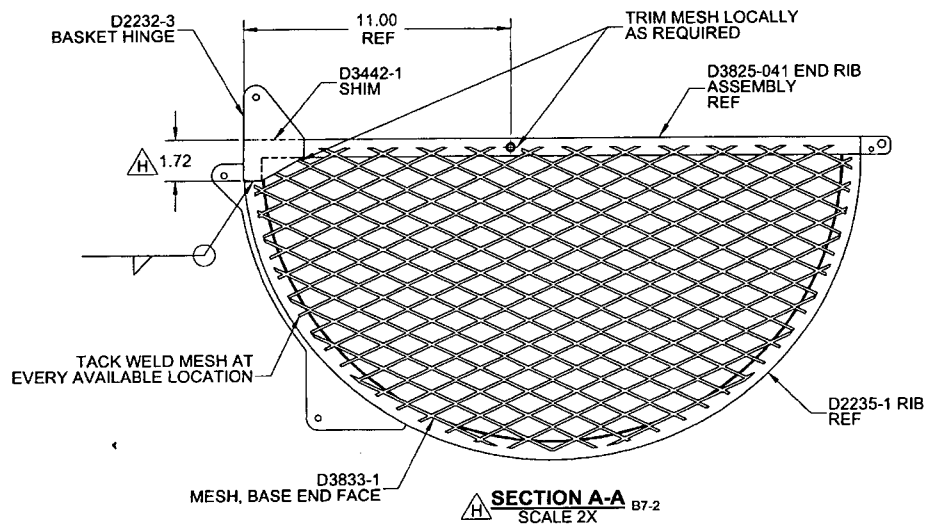
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
08/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	235	HAWKESBURY, ONTARIO, CANADA	
CHECKED	235	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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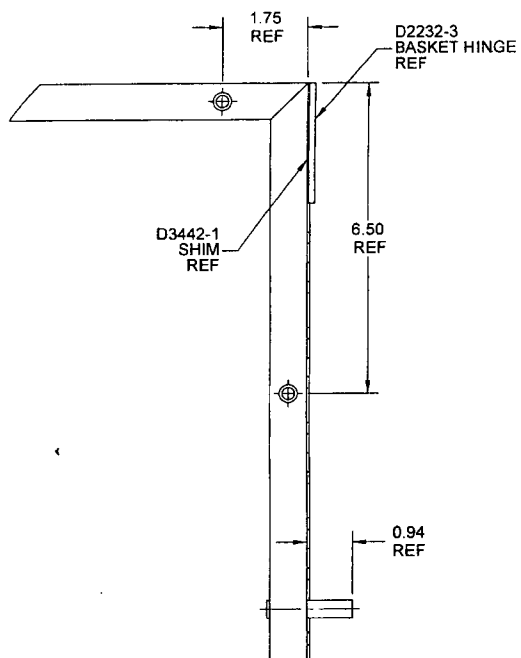
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D

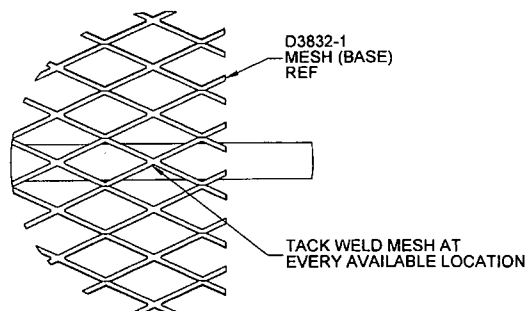
C

B

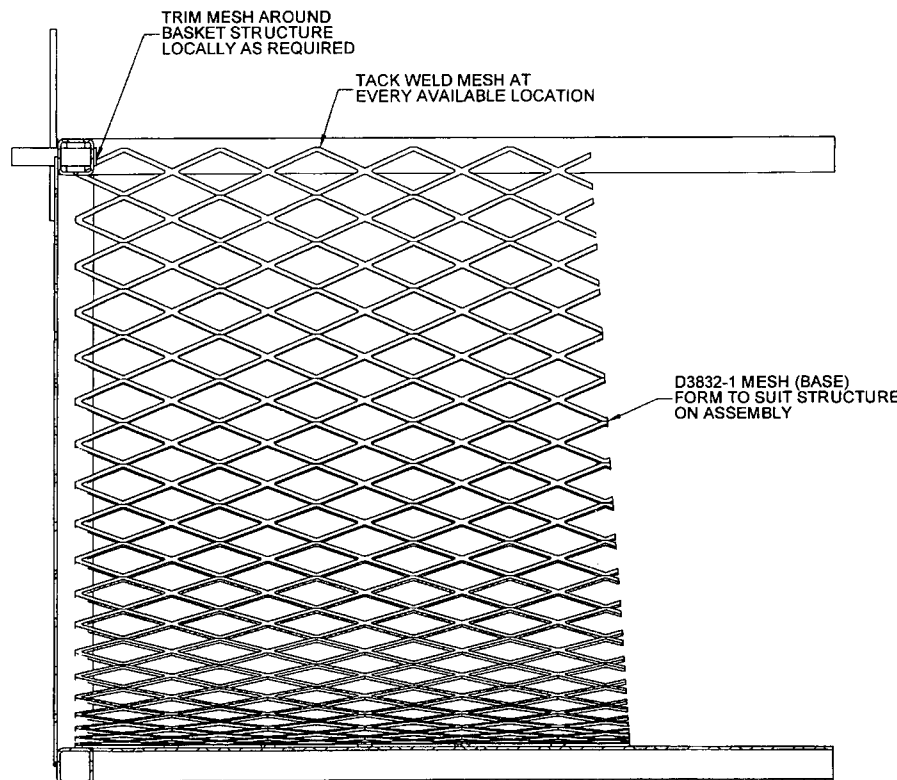
A



DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2



SECTION F-F
SCALE 4X D7-2

RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	10/8	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	10/8	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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8 7 6 5 4 3 2 1

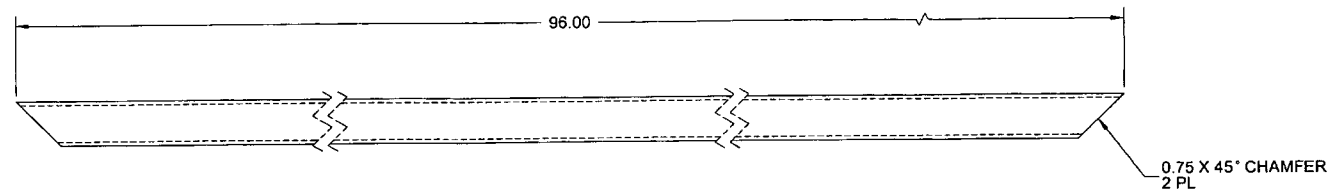
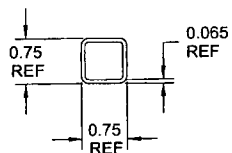
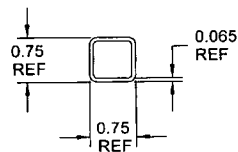
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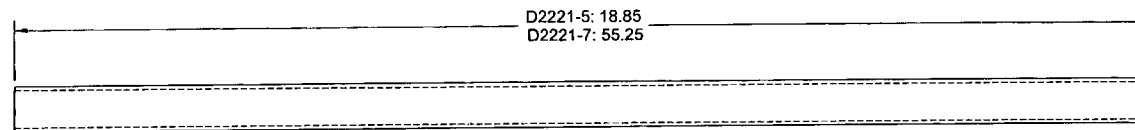
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D2221-1 RIB



D2221-5/-7 RIB

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

RELEASED
08/11/15

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	CH	BASKET BASE ASSEMBLY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries